Work Orde <i>July-31-12 9:10.</i>		707		*887					Page 1			
Revision ID:	D206-642-11 Skidtube LH	13		Accept	*N900	040	100)*	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date: Reference:	7/31/12 8/03/12	Start Qty: 1.00 Req'd Qty: 1.00	*1 *1		Cust Item II Customer:	D:						
Approvals:	Process Pla	in:	Date: Date:	Tooling: SPC (Y/N):	Date:				Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
IIN-D206-642	О											
1 \\n^ \\ DC \\ Document Control		DOCUMENT CONTR Memo Photocopy K10111	y bluefile & type lab	0.00 16 0.00 9 39 els per PPP206-642-113 CHGO						ML	J 12	-107/3
110		Pick Kit		0.00						•		
110 Packaging Packaging		Memo		0.00				_[[(2)	G/ C	73 (
120		QC4- 100% Inspect ki	its for completeness	0.00	Ž.,							
120 QC Quality Control		Memo	450	0.00								
		1	38	096	5L	H						

											DQA	A: Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE				
											QA Closed	d: Da	ate:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	Therm	Skid-tube Machining noforming Large Fab	4	Water Jer od. Eng. Coor ore/Packaging Supplie		Engineering Quality Other		
Root	[Descri	otion of work order update	1	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance			Desc	ription	Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								.*. *,						·
							AUL	T CATE	GORY					
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. t n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Und Part Incom Part Lost/ Part Move Positioned Power Los	Missing ed d Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 88707 *88707* Page 2 July-31-12 9:10:13 AM *N900040100* Accept D206-642-113 Setup Start Item ID: **Revision ID:** Stop Skidtube LH **Item Name:** Start Qty: 1.00 **Start Date:** 7/31/12 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 8/03/12 **Customer:** Reference: Run Date: Tooling: Date: Approvals: Process Plan: Stop SPC (Y/N): Date: Date: Reject Sequence ID/ Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. Operation Stamp Work Center ID Code Qty Qty Number Description **Run Hours** 0.00 130 Packaging *130* 0.00 Packaging Memo Identify and pack for shipping as per PPPD206-642-113 Packaging K10111 Location: PPP Rev:_

QC

140

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

MLJ 12/08/17 MLJ 12/08/17 12-08-17

												DQA:	Date	e:	1
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE									
											QA	Closed:	Date	e:	
Work Ord	lor.					DISPOSITION				AGAINST DE	RTMENT/	PROCESS			
Work Ord	ici.					Rework	Skid-tube Crosstube					Water Jet		Engineering	
Part	No.					Scrap	1		Machining	Small Fab	Prod. Eng. Coor.				Quality
						Use-as-is	1		noforming	Finishing	1		e/Packaging		Other
NCR	No.					Work Order Update			Large Fab	Composite]		Supplier		
									=						
Root			İ			ption of work order update	1	nitial		ction	S	ign &			
Cause	_	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Des	cription	↓	Date	Verification	<u> </u>	QC Inspector
Doc/Data															
Equip/Tooling	·														
Operator	L		1												
Material															
Setup														-	
Other											1				
Process															
Supplier							1	i							
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Land	ing (Gear				General		_		_			_		
	L	Bending				Bend		Grain			Ova	alized			Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Ov	er/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Par	rt Incorrec	t [Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Par	rt Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	3	Par	rt Moved	•		
		Heat Trea	it			Countersink		Mislabeled				sitioned W	/rong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I				Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-31-12 9:10:12 AM

Work Order ID:

88707

Parent Item:

D206-642-113

Parent Item Name:

Skidtube LH

Start Date: 7/31/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 10.12.08 PER REV.N DD VERF:EC

IPP REV:C REDESIGN PER ENG ERROR 11-11-17 JLM

No

Manufactured

IPP REV:B 11.09.23 ADDED

K10111 DD VERF:EC

VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-151		Manufactured	No			110	Each	1.0000	1	1	ag	21-5	

Replacement Skidtube

Saddle, Skidtube 206

Loc Qty Loc Code Location FG 77976

110 Each 0.0000

Jull pull rivor 1 2-00-17

											DQA:	Date:	•			
NCR: Y	es /	No				WORK ORDER NON-O	100	NFOR	MANCE / UPD	ATE						
***											QA Closed:	Date:				
Mork Orde	~ r:					DISPOSITION				AGAINST DE	ST DEPARTMENT/PROCESS					
Work Orde	er: —					Rework		Skid-tube	Crosstube	1	Water Jet	Engineering				
Part N	No.					Scrap	1	B	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
	_					Use-as-is	1		noforming	Finishing	4	re/Packaging	Other			
NCR N	No					Work Order Update]		Large Fab	Composite]	Supplier				
Root					Descri	ption of work order update	Τ	Initial	Acti	on	Sign &					
Cause		Date	Step	Qty		or Non-conformance		nief Eng	Descri		Date	Verification	QC Inspector			
Doc/Data				~-,												
Equip/Tooling							1									
Operator																
Material											1					
Setup													(3)			
Other	Ш															
Process	Ш															
Supplier																
Training	Ш				:		1									
Unapproved			<u> </u>										<u> </u>			
							AUI	LT CATE	GORY							
Landi						General		1			7		7			
						Bend	\vdash	Grain		<u> </u>	Ovalized	., <u> </u>	Pressure/Forced			
Centre Not Concentric to O/S						BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		Temperature/Cure			
	—	acks			-	Broken/Damaged	-	4	ion Incomplete		Part Incorre		Weld			
			Crimped.		<u> </u>	Burrs	-	-1	tions Incomplete/U	inclear	Part Lost/M	_	Wrong Stock Pulled			
	⊢	ıffs . . .			<u> </u>	Contamination	\vdash	Mainte		 	Part Moved					
	l lHe	eat Trea	it		1	Countersink		Mislabe	eled	}	Positioned Wrong					

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G